Work Order ID 75365 \*75365\* Page 1 October-21-11 8:16:14 AM \*N900040100\* Item ID: D3499-3 Accept Setup Start **Revision ID:** Stop Plastic Cable Guard **Item Name: Start Date:** 20/10/2011 Start Oty: 8.00 **Cust Item ID:** Req'd Qty: 8.00 **Required Date: 02/11/2011 Customer:** Reference: Run Start Process Plan:  $\mathcal{M}. \mathcal{L}. \mathcal{J}$  Date: |1|/0/2| Tooling: Date: **Approvals:** Stop Date: SPC (Y/N): Date: Sequence ID/ **Tool ID** Tool # Plan Operation Set Up/ Accept Reject Reject Insp. Work Center ID Description Code Qty Number Stamp **Run Hours Qty** Draw Nbr **Revision Nbr** D3499 Rev C 100 0.00 FLOW WATER JET \*100\* B 11-11-1 Waterjet 0.00 Memo 1-Cut as per Dwg D3499 FLOW CNC Waterjet Dwg Rev: ( Prog Rev: 2-Deburr if necessary 110 QC2- Inspect parts off machine FAI/FAIB 0.00 QC 0.00 Memo Quality Control F.F- 11/12/12 120 0.00 HAAS CNC VERTICAL MACHINING #1 \*120\* HAAS 1 0.00 1- Mill as per Folio FA636 Rev: & Dwg D3499 Rev: 🗲 HAAS CNC vertical machine #1

2-Deburr per dwg D3499

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Part No: PAR #:			Fault Cate	gory:	NCR:	es N	o <b>DQ</b>	\:	Date:			
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NCR:		- :										
DATE	STEP	Description of NC Section A	Corrective Action Initial Action Descripti Chief Eng Chief Eng			gn & Date	Verification Section C		Approval Chief Eng	Approval QC Inspector		
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Work Ord October-21-11		365		*75365*							Page 2
Item ID: Revision ID:	D3499-3			Accept	*N900	<b>040</b>	100	)*	Setup Sta	IVI	S1*
Item Name: Start Date: Required Date: Reference:	Plastic Cable 20/10/2011 : 02/11/2011	Start Qty: 8.00 Req'd Qty: 8.00	*8* *8*		Cust Item I Customer:	D:			510	r ^N	S2*
Approvals:	Process Pla	an:	Date:	Tooling: SPC (Y/N):		nte:		]	Run Sta Sto	, i	R1* R2*
Sequence ID/ Work Center II 130 *130* QC Quality Control	D	Operation Description QC2- Inspect parts off m	achine FAI/FAIB	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
*140 *140* Mill Conv Conventional Millin	ng Machine	CONVENTIONAL MIL  Memo C'BORE AS	LING MACHINE PER DWG D3499	0.00 0.00	2 U. 12.	13		_8		· ·	
150		QC2- Inspect parts off m	achine FAI/FAIB	0.00				_			

29 11. 2.13

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Quality Control

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W/O:		WORK ORDER CHANGES											
DATE	STEP	PR	OCEDURE CHAI	NGE	Е	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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Part No	<b>:</b>	PAR #:	Fault Cate	NCR:									
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NCR:		,	WORK ORD	R NON-CONFORM	ANCE (I	VCR)		·					
DATE	STEP	Description of NC Section A	Initial Action Described Chief Eng Chief Eng		stion B Sign & Date		Verification Section C		Approval Chief Eng	Approval QC Inspector			
						<u>-</u>				*****			

Work Order ID 75365 \*75365\* Page 3 October-21-11 8:16:14 AM D3499-3 Accept \*N900040100\* Setup Start Item ID: **Revision ID:** Stop Plastic Cable Guard Item Name: \*8\* Start Qty: 8.00 **Start Date:** 20/10/2011 **Cust Item ID: Required Date: 02/11/2011** Req'd Qty: 8.00 \*8\* **Customer:** Reference: Run Start Date:\_\_\_\_\_ **Tooling:** Date: **Approvals:** Process Plan: Stop SPC (Y/N): OC: Date: Date: Reject Reject Tool ID Tool # Plan Set Up/ Accept Insp. Sequence ID/ Operation Code Qty **Qty** Number Stamp **Work Center ID** Description **Run Hours** 160 OC8- Inspect parts - second check 0.00 B.A 11/12/13 8 \*160\* 0.00 OC Memo Quality Control Identify as per dwg & Stock Location 0.00 170 \*170\* Packaging 0.00 Memo Packaging 180 OC21- Final Inspection - Work Order Release 0.00 \*180\* QC 0.00 Memo

Quality Control

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W/O:			WC	RK ORDER CHANG	ES					
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	Re	esolution:	Disposition	1:	QA: N	/C Clo	sed:	·	Date:	
NCR:			WORK ORDE	R NON-CONFORM	ANCE (	NCR)				
DATE	STEP	Description of NC	Corrective Action Section B			Sign &	Verific	ation	Approval	Approval
- DAIL	JILF	Section A	Ínitiai Chief Eng				Section C		Chief Eng	QC Inspector
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#### **Picklist Print**

October-21-11 8:16:18 AM

Work Order ID: 75365

\*75365\*

Parent Item: D3499-3 \*D3499-3\*

Parent Item Name: Plastic Cable Guard

Start Date: 20/10/2011

109313

**Required Date:** 02/11/2011

Page 1

Start Qty: 8.00

Required Qty: 8.00

**Comments:** 

IPP Rev:A New Issue 06-05-05 JLM

IPP Rev:B As per Rev B 06-08-31 JLM

IPP Rev:C as per dwg

revC DD 10.02.23 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Prima Item Locat	 Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB625		Purchased	No	 110	sf	3.0000	1.081	9.103158	}		
*MUHMW UHMW .625 Black Tivar I							**	18	[[-((-	-1	·

Location Loc Qty Loc Code MAT018 3 109313 3

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DATE	STEP	Description of NC		Section B	0:	Verific	ation	Approval Chief Eng	Approval	
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DART AEROSPACE LTD	Work Order:	75365
Description: Cable Guard	Part Number:	D3499-3
Inspection Dwg: D3499 Rev: B		Page 1 of 1

#### FIRST ARTICLE INSPECTION CHECKLIST

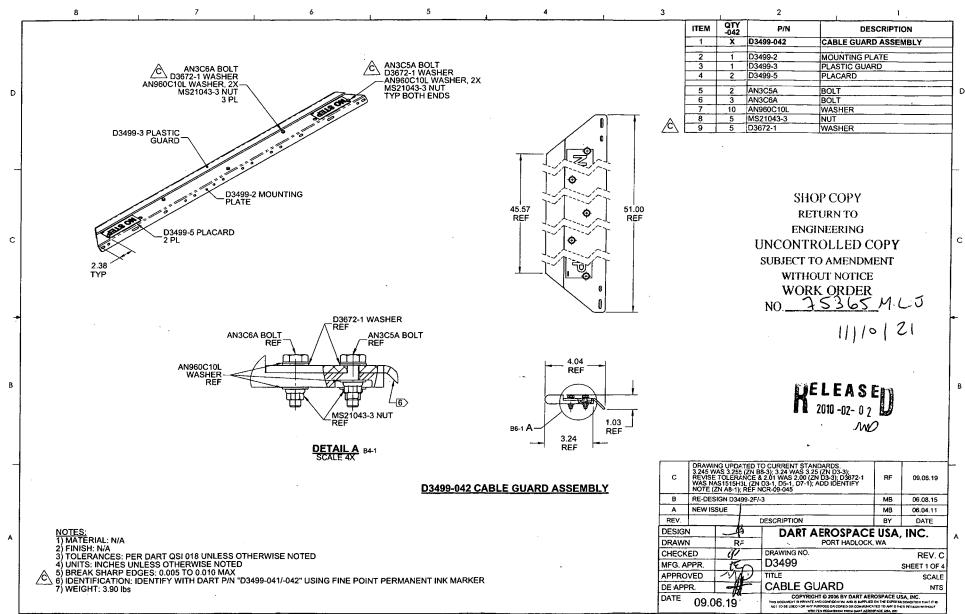
X First Art	cle	Prototype
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	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
	Ø0.201	+0.005/-0.001	. 206.	7		FK=04	Vern:
	Ø0.500	+0.006/-0.001	250G	7		1	1
*	3.255	+/-0.010	3.257	7		/1	1
	47.900	+/-0.010	F1-800	7		FK-05	Tank
	1.755	+/-0.010	1.751	7		FK-041	Vern.
	0.950	+/-0.010	,950	7		11	"
	2.605	+/-0.010	2.605	7		11	4
	40.700	+/-0.010	40,700	7		FK. 05	Tape
	12.450	+/-0.010	12.450	7		1/	1,
	0.25	+/-0.030	270	7		F. F 64	Vecn:
	0.63	+/-0.030	.625	7		1	',
	3.25	+/-0.030	3.257	7		7,	11
	2.0	+0.000/-0.030	2.0\$2	1		1)	<b>'</b>
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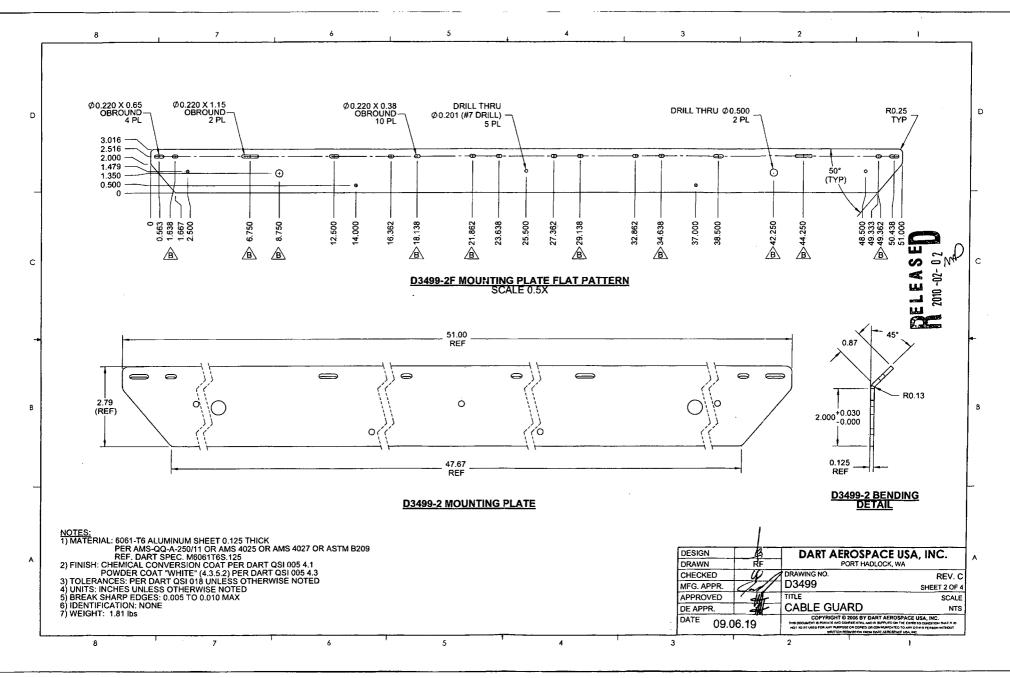
Measured by:	#-K-	Audited by:	b.A	Prototype Approval:	N/A
Date:	11/12/12	Date:	11/12/13	Date:	N/A

Rev	Date	Change	Revised by	Approvéd
A	06.09.27	New Issue	KJ/JLM X	ad
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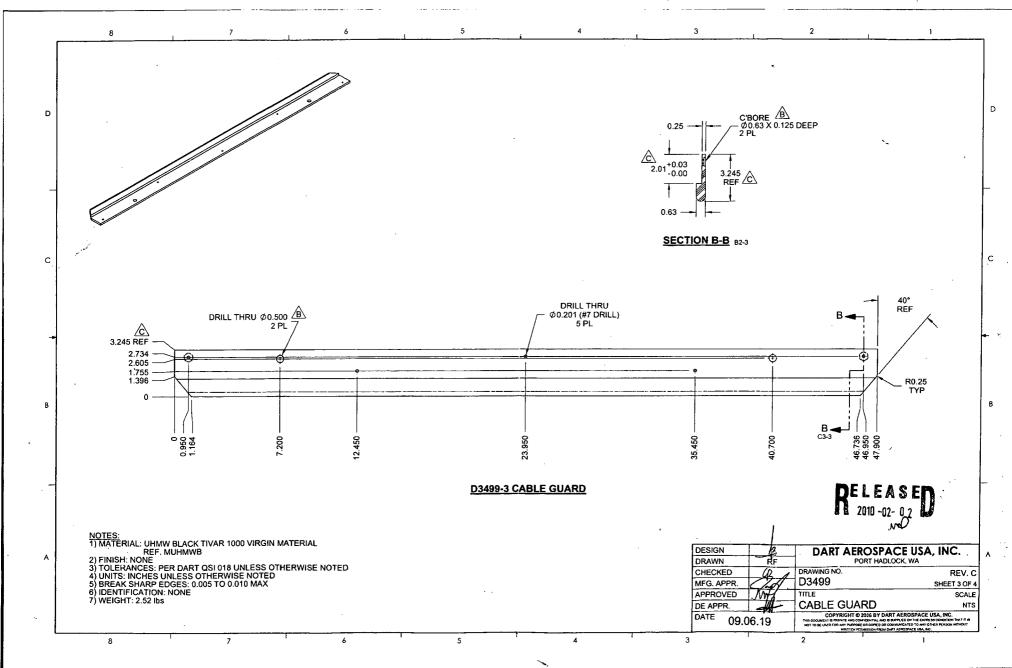
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DATE	STEP Description of NC Section A	Description of NC		Corrective Action Section		Verificat	ion Approval	Approval
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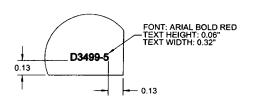
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NCR:	***************************************		WORK ORD	ER NON-CONFORM	ANCE (NC	R)								
D.475	0750	Description of NC			ction B	Verific	ation	Approval	Approval					
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FONT: ARIAL BOLD RED -TEXT HEIGHT: 0.88" TEXT WIDTH: 5.17" 0.43 NO STEP 1.75 0.44

D3499-5 PLACARD



DETAIL C B5-4

NOTES:
1) MATERIAL: RED LETTERS ON WHITE ADHESIVE BACK VINYL
MANUFACTURED FROM 3M 7 MIL MASKING FILM #8522CP OR
AVERY IPM #2031. SIZE IS 6.00" LONG" x 1.75" WIDE

- 2) FINISH: N/A
  3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  4) UNITS: INCHES UNLESS OTHERWISE NOTED
  5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  6) IDENTIFICATION: NONE
  7) WEIGHT: N/A

D

С

DESIGN	1	DART AEROSPACE			
CHECKED	RF	DRAWING NO.	REV. C		
MFG. APPR.	11.	D3499	SHEET 4 OF 4		
APPROVED	74	TITLE	SCALE		
DE APPR.	4	CABLE GUARD	NTS		
DATE 09.0	06.19	COPYRIGHT @ 2006 BY DART AEROSPACE USA, INC. THIS COCUMENT IS PRIVATE AND COMPENHAL WID IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PAREOUS OR COMED ON COMMANDATED TO ANY OTHER PRISODS WITHOUT WITH PRESSURE PRISONS USER AND ANY PAREOUS USER INC.			

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